

**UNITED STATES DEPARTMENT OF AGRICULTURE
AGRICULTURAL MARKETING SERVICE
LIVESTOCK AND SEED PROGRAM**

APPROVED

TECHNICAL DATA SUPPLEMENT (TDS) - LM
USDA/ AMS/ LS PROGRAM/ STDZ/Rm. 2603
EFFECTIVE FEBRUARY 2001

**ITEM DESCRIPTION AND
CHECKLIST OF REQUIREMENTS
CANNED LUNCHEON MEAT
PRODUCT CODE A617 AND A621**

This document is for use by the United States Department of Agriculture (USDA) for the procurement of Canned Luncheon Meat: (1) Beef, (2) Pork, and (3) Combination of Beef and Pork. Contractors will document their processes to ensure compliance with the following ITEM DESCRIPTION and CHECKLIST OF REQUIREMENTS. The USDA, Agricultural Marketing Service (AMS), Livestock and Seed Program (LSP), Meat Grading and Certification Branch (MGCB), Quality Systems Operations will verify compliance in accordance with the QUALITY ASSURANCE section.

I. ITEM DESCRIPTION

Canned Luncheon Meat: The purchaser will specify the type of luncheon meat to be purchased. The Meat component of the three types shall be: 1) Beef, 2) Pork or 3) a combination of Beef and Pork that consists of not less than 30 percent beef or 30 percent pork. The luncheon meat will also contain curing ingredients, sweetening agents, spices, and salt. The product shall have a slightly to moderately coarse texture and hold together as an intact unit when removed from the can. The product, shall be uniform in color in a range, depending on formulation, of: 1) Beef - dark pink to reddish brown, 2) Pork - pink to dark pink, and 3) Beef and Pork - dark pink to light reddish brown. A slight color variation between internal and external surfaces is permitted. The salt content shall be no less than 1.5% nor more than 2.50%. The targeted average fat content shall not exceed 19%.

These items will be produced in accordance with Food Safety and Inspection Service (FSIS) regulations and the following CHECKLIST OF REQUIREMENTS.

II. CHECKLIST OF REQUIREMENTS

A. MEAT COMPONENTS

1. Meat must be derived from U.S. produced livestock only. U.S. produced means manufactured from hogs or cattle raised in the United States, its possessions, Puerto Rico, or the Trust Territory of the Pacific Islands. U.S. produced does not include imported beef or pork, nor cattle or hogs imported for direct slaughter.
2. Non-ambulatory (downer) Operating Policy – Beef and Pork must originate from slaughter establishments that handle non-ambulatory livestock (hogs or cattle unable to walk under their own power) commonly known as “downers” in accordance with FSIS Directive 6900.1R1 – Humane Handling of Disabled Livestock, issued 11/02/98. Carcasses originating from such animals must be segregated and the product from them cannot be included in USDA purchased Canned Luncheon Meat.

3. Canned Luncheon Meat shall be in compliance with Institutional Meat Purchase Specifications (IMPS) for Sausage Products, Series 800, effective, November 1992, Item No. 825.
4. Temperature and time limitations - The contractor must have, and adhere to, process documentation that describes the processing schedule to ensure that the boneless meat maintains excellent condition up to processing (canning).
5. Metal Detection - The contractor's documentation must identify and adequately describe their detection procedures, equipment, detection levels, testing frequency, and location of testing. They must also demonstrate to AMS how they will check the product in-plant to **ensure that the end item is free from metal contamination**. This may be accomplished by running product, with known metal contaminants, through their process while the auditors observe the results.
6. Product shall be placed in 30-ounce or 6-pound cans, vacuumized, sealed, and thermally processed in accordance with FSIS Regulations.

B. NONMEAT COMPONENTS

The formula shall include: no less than 1.5% nor more than 2.50% salt; curing ingredients; sweetening agents; spices; and flavorings that are used to produce commercial luncheon meat. Compliance with requirements for salt and other ingredients shall be in accordance with FSIS Regulations.

C. FAT LIMITATIONS

1. The Contractor will declare a fat target not to exceed 19.0 percent. The fat content will be declared on the shipping container label or nutrition facts panel on the can label. Percent fat = (Total fat per serving ? Serving size) x 100).
2. Process Control - Product shall be derived from a process that is in statistical control and is capable of meeting this specification's requirements. The contractor shall maintain statistical process control procedures for fat content that are monitored by FSIS and made available for process capability assessment by AMS.
 - a) The contractors shall maintain control charts with statistically derived upper control limits (+ 3 standard deviations). Control charts will be used to determine if the process is in statistical control.
 - b) The contractor will have at least four (4) samples (prior to canning) of ground product analyzed for fat content from each production lot destined for AMS. The samples will be analyzed for fat content and the results will be plotted on control charts featuring average and range of the results of the sample units.

- c) The contractor shall target production and maintain a process average for fat content of 19.0 percent or less. No product shall be shipped from production lots that:
 - (1) Have average results in a lot exceeding 21.0 percent; or
 - (2) Are produced while the process average exceeds 19.0 percent.

D. PACKAGING, PACKING, AND CLOSURE

1. CANS

The 30-ounce cans will be open top style, cylindrical, and size (approximately) 401 x 411 or 404 x 404. The 6-pound cans will be (irregular/rectangular) meat can, and size 400 x 400 x 1106 to 1110. The cans will be coated with enamel (or other suitable material) inside and outside.

2. PACKING

For 30-ounce cans, 24 cans will be placed into each shipping container. For 6-pound cans, six cans will be placed into each shipping container.

3. CLOSURE

Shipping containers will be closed by strapping, taping or gluing. When strapping is used, the initial closure (usually the bottom of container) shall be secured by the gluing or taping method.

4. MARKING OF CONTAINERS

- a) Cans – Can labels shall appear as shown in Exhibit A (attached). The Nutrition Facts panel is required on the 30-ounce can only. The Nutrition Facts must comply with USDA-FSIS regulation 9 CFR 317 and 320. For State inspected plants, nutrition labels must be in accordance with State regulations that are equal to 9 CFR Parts 317 and 320.
- b) Shipping containers – Shipping containers shall contain all information shown in Exhibit B. However, contractors may vary the placement of the required information shown in Exhibit B. Additional markings (e.g., company bar codes, company names, logos, etc.), that are consistent with all other commercial labels, may be included. The net weight for 24/30-ounce cans will be 45.0 pounds. (Product Code A617). The net weight for 6/6-pound cans will be 36.0 pounds. (Product Code A621). **The Universal Product Code does not apply to the 6-pound can of luncheon meat or its shipping container.**

5. PALLETIZED UNIT LOADS

Required, see IMPS General Requirements (Effective June 1996).

III. QUALITY ASSURANCE

A. DEFINITION OF TERMS

1. Product Sample - a sample of 12 cans of product will be evaluated for compliance with the Item Description and Checklist of Requirements.
2. Production Standard - a Product Sample which meets all of the criteria listed under the Submission of Documentation and Sample section. It will be used to evaluate future production.
3. Supplier Assessment - an in-plant evaluation (prior to bidding) of the potential contractor's ability to supply product that meets the checklist of requirements.
4. Production Process Documentation - documented production processes and records (paper trail) that ensures the product is produced in accordance with the Item Description and Checklist of Requirements.
5. Post-Award Audit - an in-plant evaluation of the production process and the applicable documentation.
6. Post-Production Evaluations - Contractor evaluation of product after thermal processing.
7. Continuous improvement point – a minor nonconformance that, although it needs to be corrected in a timely manner, does not compromise the integrity of the products or program. Isolated incidences of nonconformance should be considered continuous improvement points.
8. Hold point – a major nonconformance that compromises the integrity of the products or program. Any absence or complete breakdown in a required element should be considered a hold point. An accumulation of continuous improvement points may also result in the assignment of a hold for an audit.

B. CONTRACTOR'S RESPONSIBILITY

1. Submission of Documentation and Sample--Prior to bidding, potential suppliers will submit to the contracting officer:
 - a) A written description of their production processes, (which must include procedures for internal review, and control of nonconforming product, resampling procedures, tracking, and complaint resolution), raw materials used, an ingredient statement, and a documented quality control program that addresses contractor's quality assurance measures to ensure compliance with the above Item Descriptions and Checklist of Requirements.

- b) A product sample (12 cans of product) and related Nutrition Facts panel that conforms to the Item Description and Checklist of Requirements (at no expense to the Government). Four (4) cans will be evaluated from the 12 cans to determine the supplier's capability to furnish an acceptable product. After the product sample is evaluated and found to meet the criteria listed below, the unopened cans will be kept as a production standard. The product sample will be evaluated for the following criteria:

Packaging and Packing

- Style, size, shape, and coating requirements of cans.
- Appropriate Marking of Containers (can labels).

External Product Characteristics

- There is no presence of foreign odor or flavor (e.g., burnt, scorched, moldy, rancid, sour, or stale).
- Product remains intact when removed from can.
- There is no presence of fat covering more than 10 percent of the outer surface.

Internal Product Characteristics

- Product has uniform color ranging from: Type 1) beef - dark pink to reddish brown, Type 2) pork – pink to dark pink, Type 3) combination beef/pork – dark pink to light reddish brown.
- Product yields an intact slice 0.2 inch thick, which remains intact when gently shaken and free of broken edges (crumbling).
- Product is free of pockets of air, fat, or gelatin that are greater than 0.3 inch in the longest dimension.
- Product is free of unauthorized materials, which affect the usability of the product such as bone, cartilage, foreign material.

If USDA determines that the product sample does not meet the above criteria, the supplier will have the opportunity to resubmit other samples with corresponding modifications in their process documentation.

- c) Any changes in the process description must be submitted for reevaluation and approval prior to implementation to:

USDA, AMS, Livestock and Seed Program

Contracting Officer

Commodity Procurement Branch

Stop 0253, Room 2610 S Bldg

1400 Independence Ave. SW

Washington, D.C. 20250-0253

Phone (202) 720-2650

Fax (202) 720-9538

2. **Supplier Assessment**--After the product sample and supporting documentation are evaluated and approved, an AMS audit team will perform an in-plant supplier assessment of the facilities, processes, and quality control program used to produce the production standard. The supplier assessment consists of an onsite pre-award audit to determine the supplier's ability to meet contractual requirements. The audit will include, but is not limited to, a thorough evaluation of the potential contractor's and subcontractor's facilities, equipment, procedures, and all reference documents. Documentation must support the Item Description and Checklist of Requirements. A detailed review of purchasing, receiving, production, quality control, inventory, shipping records, and interviews with management and production personnel will be conducted.
3. **Post-Award Audits**—One post-award audit will be performed monthly or during each contract, and possibly more frequently if deficiencies are found. The cost of all pre-award and post-award audits, including travel expenses, will be the responsibility of the contractor. The contractor will have process documentation and written quality control records that support the Item Description and Checklist of Requirements. All written procedures and associated records will be maintained and readily available for review by AMS agents. Records may be maintained on hard copy or electronic media. However, records maintained on electronic media will be made available in hard copy immediately upon request by AMS. A control copy of the contractor's approved production process documentation and quality control program will be maintained by the MGCB quality manager. The contractor's production process documentation will include:
 - a) Documentation that provides objective evidence that the end item complies with the ITEM DESCRIPTION AND CHECKLIST OF REQUIREMENTS. Product will be labeled and identified in such a manner as to ensure that the finished product may be traced to corresponding quality control records.
 - b) Procedures for internal review and control of nonconforming product.
 - c) Re-sampling procedures.
 - d) Documented plans for corrective action when deficiencies are found.
 - e) Post-Production Evaluation--The post-production evaluations will address condition of cans and the finished product's appearance, odor, and flavor.
4. **Audit Reports** – MGCB will submit copies of all supplier assessment and post-award audit reports to the Contractor and Contracting Officer. The reports will provide a basis upon which the Contractor will take corrective or preventative actions and for the Contracting Officer to determine acceptance of delivery of products. In the event of the assignment of a hold point, the Contracting Officer may require corrective action prior to further production or shipping.

C. CHECKLOADING OPTIONS

Option 1.

At the request of the contractor, an AMS agent (on a fee basis) will checkload the product at the time of shipment and perform the following duties:

1. Conduct a final examination of condition of shipping containers that will be limited to scanning (without destructive sampling) the delivery unit for defects which may have occurred during handling and storage (e.g., crushed, torn, dirty, stained, etc.). All defective containers must be replaced or corrected as applicable.
2. Supervise the loading and sealing of each truck.
3. Issue a final Acceptance Certificate, thereby allowing the Contractor to immediately submit invoice for payment to USDA. The AMS agent shall set forth on the original certificate the following:
 - a) Contract number
 - b) Notice-to-Deliver number
 - c) Name of product
 - d) Six Digit Commodity Code for 24/30 ounce cans (244050) and 6/6 pound cans (244060).
 - e) Production lot number(s), can codes and the date each lot was produced.
 - f) Count of shipping containers and total projected net weight in each production lot.
 - g) Total projected net weights per delivery unit. The delivery unit for the 30-ounce cans will be 36,000 pounds net weight (800 cases). The delivery unit for the 6-pound cans will be 36,000 pounds net weight (1000 cases). No tolerance from the quantity called for in the shipping instruction shall be permitted except that a variation of plus or minus 15 shipping containers of product shall be allowed only on the final shipment of each contract.
 - h) Identity of conveyance (numbers and letters, seals, license, etc.) as applicable.
 - i) Destination(s)

Option 2.



If the contractor chooses to not have an AMS agent perform checkloading at the time of shipment, invoices for payment must be supported by: (1) a recipient's signature on the bill of lading; (2) a consignee's receipt evidencing date shipped and received; or (3) other commercial receipt evidencing delivery of the product. In all cases the information contained in Section C., Option 1. 3., a through i, and a statement that: "**Product conforms to the (Item Description and Checklist of Requirements for Canned, Luncheon Meat)**" must be included.

EXHIBIT A

CAN LABEL DESIGN:

In conjunction with other markings that may be required by FSIS Regulations, each can shall be lithographed or paper labeled essentially as shown below. If paper labels are used, they shall be made of white durable stock and securely attached to the can. Paper labels for 30-ounce cans shall be full wrap around. Lithographing or printing shall be black. Markings for the 6-pound can should be as shown below for use on one side panel only and must measure at least 2 ¾ inches in width and 6 inches in height. The labels must be approved by USDA, FSIS prior to use in the program. In accordance with the UPC guidelines published by the Uniform Code Council (UCC), a 12 digit UPC code and symbol which consists of the number as illustrated below for each commodity must appear on each can.

30-OUNCE CAN

	<p>Nutrition Facts</p>	
	<p>Ingredients:</p>	<p>Bar Code:</p>
	<p>Name and Address of Contractor</p>	<p>715001016195</p>



6-POUND CAN

<p>LUNCHEON MEAT</p>

<p>Distributed by USDA in cooperation with State and local or tribal governments for domestic food assistance programs.</p>
<p>Ingredients:</p>
<p>Name and Address of Contractor</p>
<p>Net Wt. 6 LBS (2.72 KG)</p>


EXHIBIT B

SHIPPING CONTAINER MARKINGS: Shipping containers for 30-ounce cans shall be marked substantially as shown below. A 14 digit I 2/5 bar code must appear on each shipping container. For 6-pound cans appropriate changes shall be made in the can size and net weight statements. The fat declaration statement shown below only applies to the 6-pound cans. The required markings shall be black, flat, waterfast, and nonsmearing. Information may be printed or stenciled directly on the shipping containers or mechanically printed, pressure sensitive labels may be applied provided they cannot be removed in an intact form. The USDA symbol shall be at least 3 and half inches high. All other printing of stenciling shall be of a size and contrasting color to stand out prominently and comply with the USDA-FSIS regulations or State regulations.

	<p>DONATED BY THE U.S. DEPARTMENT OF AGRICULTURE FOR FOOD HELP PROGRAMS</p> <p>NOT TO BE SOLD OR EXCHANGED</p> <div style="text-align: center; margin: 20px 0;">  </div> <p>STORE IN COOL DRY PLACE</p>	<div style="border: 1px solid black; padding: 5px; width: 50px; margin: auto;"> <p style="writing-mode: vertical-rl; transform: rotate(180deg);">*Bar Code</p> </div>
	<div style="display: flex; justify-content: space-between;"> <div style="width: 45%;"> <p>(BEEF OR PORK) CANNED LUNCHEON MEAT 24/30 OZ. (850g) cans</p> <p>Product Code: _____</p> <p>Fat Declaration _____</p> <p>CONTRACT NO. _____</p> </div> <div style="width: 45%;"> <p>DATE PACKED _____</p> <p>Can Code: _____</p> <p>Lot # _____</p> <p style="text-align: center; margin-top: 20px;">NET WT. 45.0 LBS.</p> </div> </div> <div style="text-align: right; margin-top: 20px;">  </div>	

* A UPC shipping container code (Interleaved 2 of 5 (I 2/5) must appear on the lower corner of one side panel of each shipping container. The 14-digit code for Canned Luncheon will be 10715001016192. **The Universal Product Code does not apply to the 6-pound can of luncheon meat or its shipping container.**